



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-121
Job Sheet 175504



Part No: D350-591-121

Job Qty: 4 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/27/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/26/18	0.00	0.00	Start Up Large Fab-4		DC 2018-04-04
110	Large Fab	4 pcs		4/26/18	0.00	2.72	Large Fab 8		DC 2018-04-04
120	CNC Bend Skidtubes	4 pcs		4/26/18	0.38	1.17	CNC Bend Skidtube		DC 10-04-11
122	QC	4 pcs		4/26/18	0.00	0.00	QC5		SLG
140	Large Fab	4 pcs		4/26/18	0.00	2.72	Large Fab 2		DC 12-04-25
150	QC	4 pcs		4/26/18	0.00	0.00	QC9		DC 10-04-25
160	QC	4 pcs		4/26/18	0.00	0.00	QC5		SA 8-04-27
170	HandFinish	4 pcs		4/26/18	0.00	0.74	HandFinish1		CPL
180	QC	4 pcs		4/26/18	0.00	0.00	QC7-2		SLG
190	Large Fab	4 pcs		4/26/18	0.00	2.72	Large Fab 2		CPL
220	QC	4 pcs		4/26/18	0.00	0.00	QC10		DC 18-05-04
230	QC	4 pcs		4/26/18	0.00	0.00	QC5		BR 18-5-04
240	HandFinish	4 pcs		4/26/18	0.00	0.74	HandFinish1		DC 18-05-04
250	Powdercoat	4 pcs		4/26/18	0.00	0.65	Powdercoat1		38
260	HandFinish	4 pcs		4/27/18	0.00	0.74	HandFinish3		MAY 07 2018
270	QC	4 pcs		4/27/18	0.00	0.00	QC3		7/11 AD
280	Packaging	4 pcs		4/27/18	0.00	0.00	Packaging1-3		7/11 AD
290	QC	4 pcs		4/27/18	0.00	0.00	QC4		
295	DC	4 pcs		4/27/18	0.00	0.00	DC		
300	Packaging	4 pcs		4/27/18	0.00	0.00	Packaging3-1		
310	QC21-FG	4 Ea		4/27/18	0.00	0.00	QC21		MAY 07 2018

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using DT8230.

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod M38733-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 3-Grind end plate flush.

250 - START TIME: 9:35 OVEN TEMPERATURE: 320° FINISH TIME: 10:05

295 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

5058780x3

F9039

wing walk M138761

2739

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (.5 ea)	90-Start up Operation	
D2850-1	End Bracket	4 Ea (1 ea)	140-Large Fab	F14990 / 5064279
D2582	Hi-Skid Step Leg Assembly	4 Ea (1 ea)	190-Large Fab	
D2673-34	End Plate	4 Ea (1 ea)	190-Large Fab	
MS20600-AD4W3	Cherry Rivet	64 Ea (16 ea)	190-Large Fab	
AN3-37A	Bolt	6 Ea (2 ea)	280-Packaging	5041154
AN4-13A	Bolt	3 Ea (1 ea)	280-Packaging	5054119
AN4-16A	Bolt	6 Ea (2 ea)	280-Packaging	5057519
D2230-1	Mounting Lug	3 Ea (1 ea)	280-Packaging	5065883
D2230-3	Mounting Lug	3 Ea (1 ea)	280-Packaging	5051382
D2732-030	Rubber Cushion - 3"	6 Ea (2 ea)	280-Packaging	504480
MS21042L3	Nut	6 Ea (2 ea)	280-Packaging	5062372
MS21042L4	Nut	9 Ea (3 ea)	280-Packaging	5054118
NAS1149D0363J	Washer	12 Ea (4 ea)	280-Packaging	5018269
NAS1149D0463J	Washer	18 Ea (6 ea)	280-Packaging	5055952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	160	0
140-Large Fab	D2850-1	4	4	0
190-Large Fab	D2582	4	1	0
	D2673-34	4	25	0
	MS20600-AD4W3	64	395	0
280-Packaging	AN3-37A	6	90	0
	AN4-13A	3	900	0
	AN4-16A	6	214	0
	D2230-1	3	4	0
	D2230-3	3	154	0
	D2732-030	6	171	0
	MS21042L3	6	2,571	0
	MS21042L4	9	3,873	0
	NAS1149D0363J	12	2,931	0
	NAS1149D0463J	18	5,730	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



QA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
DART Aerospace Ltd. 1270 Aberdeen Street Hertsburg, ON K8A 1K7 CANADA TEL.: 1 813 632-8200 Email: sales@dartaero.com www.dartaero.com		Date: 04/06/18		Lead hand / Supervisor Approval Verification																	
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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hell-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hell-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hell-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hell-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hell-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hell-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hell-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

Change Record

PAGE 1 OF 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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